

Date: Friday, 5/25/2007 8:36:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET
Job Number	: 32647			
Estimate Number	: 12529			
P.O. Number	: N/A		Part Number	: D35571
This Issue	: 5/25/2007	S.O. No. : N/A	Drawing Number	: D3557 REVA
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: A
Previous Run	: 31126		Material	: N/A
Written By			Due Date	: 6/6/2007
Checked & Approved By			Qty:	20
Comment	: Est Rev:A New Issue 06-09-18 JLM		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
Comment: Qty.: 0.0360 sf(s)/Unit Total : <u>0.3602 sf(s) 07/204</u> 6061-T6 0.125 Sheet (M6061T6S0125) Batch: <u>M104366</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3557 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> ****Ensure Grain Direction is Correct****		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg D3557		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 32647

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JL En 07/06/19

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



QX

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.d 07/06

8.0 POWDER COATING POWDER COATING



20

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M.d 07-06-20

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



07/06/21 20

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JL 07/06/21

10.0 PACKAGING 1 PACKAGING RESOURCE #1



20

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 117

FINAL INSPECTION/W/O RELEASE

L 7/6/21 50 20

11.0 QC21



20

Comment: FINAL INSPECTION/W/O RELEASE

R 07/06/22

Job Completion



W 07/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32647
Description: Bracket	Part Number:	D3557-1
Inspection Dwg: D3557	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	M. M.
Date:	07 05 30

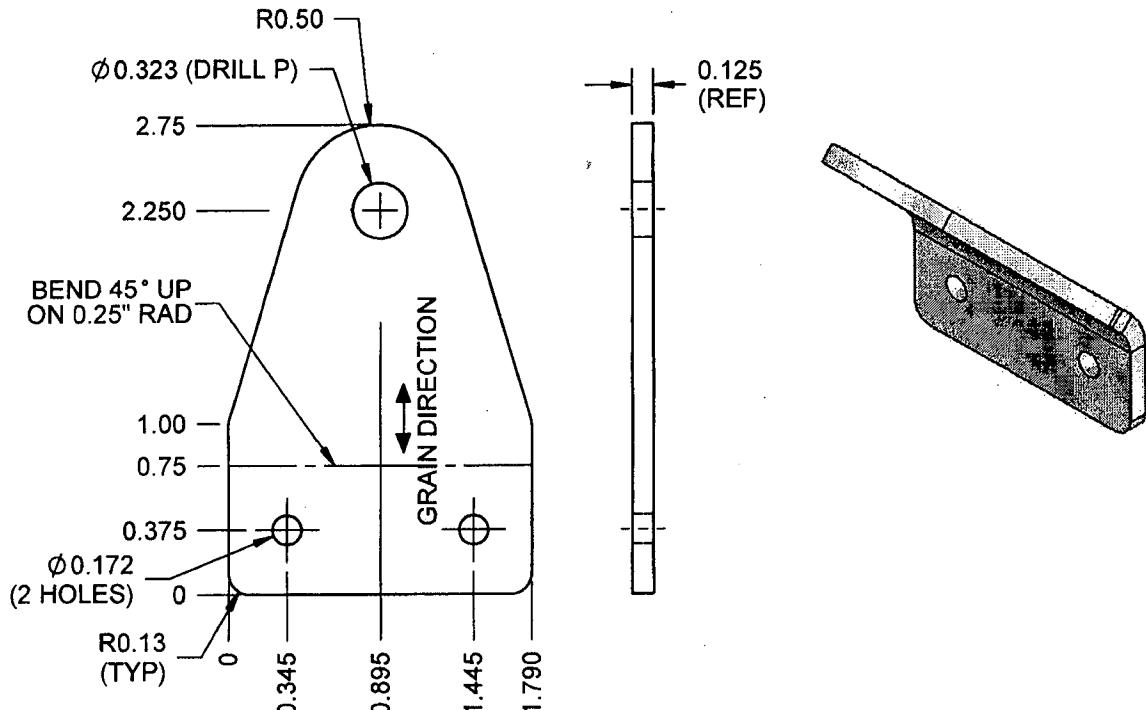
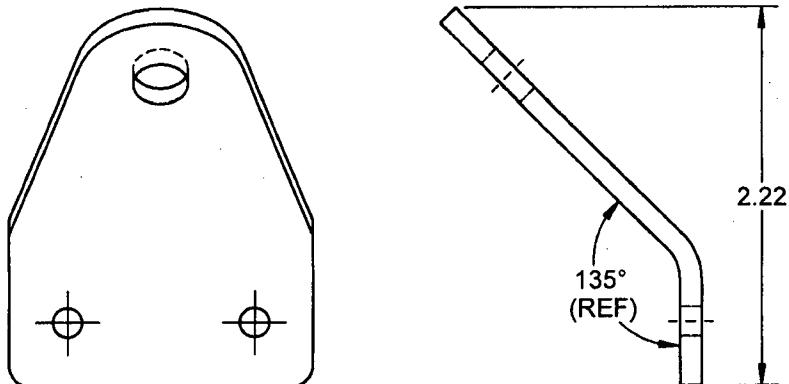
Audited by:	<i>[Signature]</i>
Date:	07-05-30

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	E

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>JF</i>	DRAWING NO. D3557	REV. A	SHEET 1 OF 1
DATE 06.09.15		TITLE BRACKET	SCALE	1:1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE		

**D3557-1F FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *32647*

D3557-1 BRACKET**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER

RELEASED

06-10-13